

Ship Monday 10/12

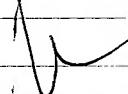
Work Order ID 94314

94314

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December-07-12 9:25:56 AM

Item ID: D3805-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 12/06/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/07/12 Req'd Qty: 1.00 *1* Customer: CU-DAR001
 Reference: RMA RA111454

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	B								

100

0.00

100

QC

Quality Control

Memo

INSPECT RA111454

0.00
 DAS
 16
 12/12/07

110

0.00


110

Large Fab

Large Fab

Memo

REMOVE D3807-5 RUBBER GASKET- DISCARD
 REMOVE GLUE
 REMOVE PAINT AND CLEAN AREA WHERE WELD IS REQ'D

1  BL 12-12-7

120

0.00

120

Large Fab

Large Fab

Memo

RE-WELD CRACKED AREA
 SEE ATTACHED RS1009

①  12-12-7

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130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 *150* Powdercoat Powder Coating	Powder Coat Orange Safety Memo	0.00 0.00							

12.12.10

12.12.10

Start Time: 10:00
Temp: 13200F
Finish Time: 10:30
12/12/10

M12243

Work Order ID 94314



94314

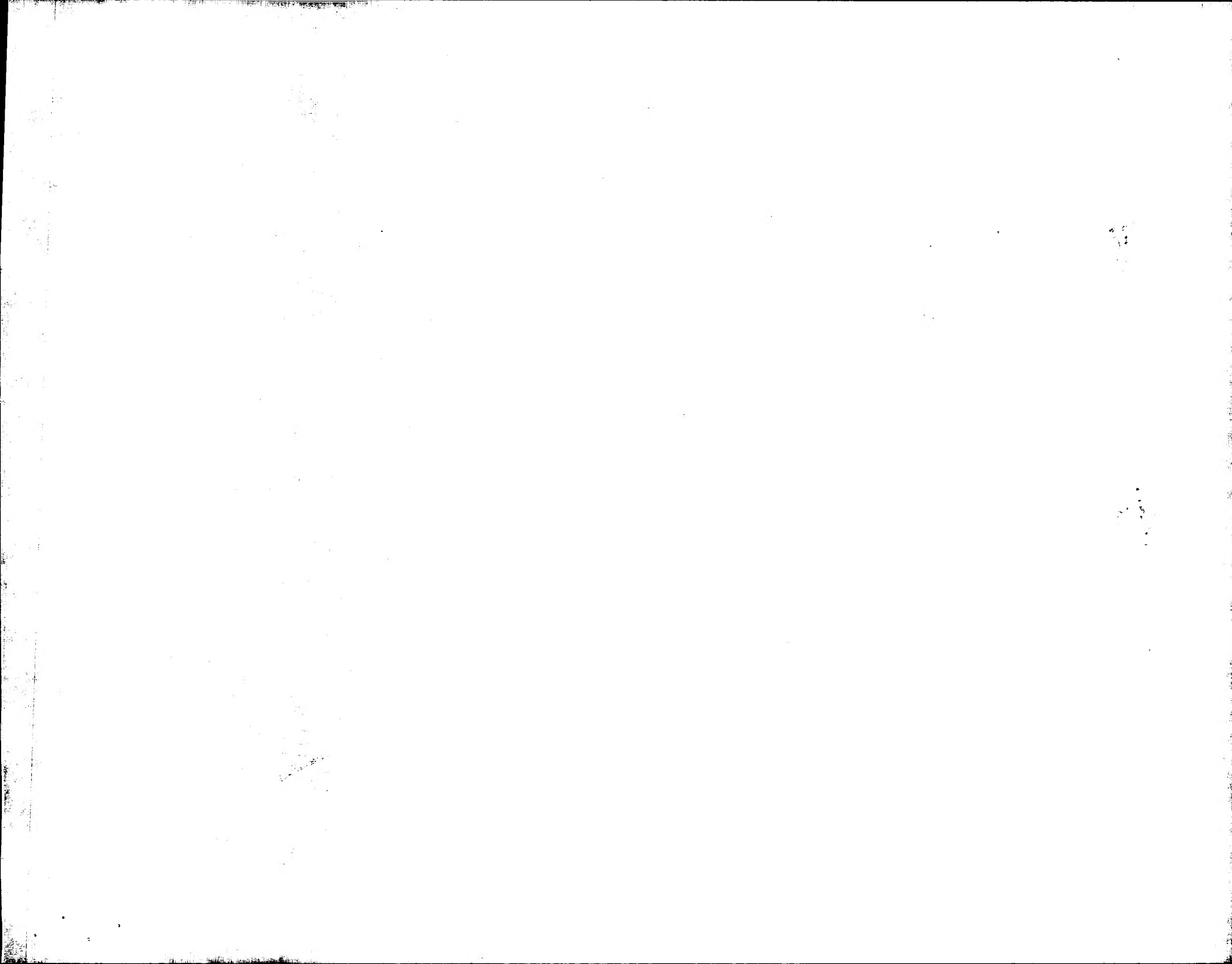
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	0	12-12-10	
170 *170* Small Fab Small Fab	Memo INSTALL RUBBER GASKET AS PER DRWG D3805 WITH 3M SCOTCH GRIP ADHESIVE B 123676 D3807-5 B 92779	0.00 0.00				1	0	12-12-10	
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1	0	12-12-10	



Work Order ID 94314***94314***

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December-07-12 9:25:56 AM

Item ID: D3805-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 12/06/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 1.00

1

Customer: CU-DAR001

Reference: RMA RA111454

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
100									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control	ATTN: NO ARC - this is a repaired part								

ML5 12-12-10

ML5 12-12-10

Picklist Print

December-07-12 9:25:55 AM

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Work Order ID: 94314

Parent Item: D3805-045

Start Date: 12/06/12

Required Date: 12/07/12

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-045		Manufactured	No				Each	14.0000		1		12-12-7	
Wearplate Assembly Aft, Low Gear													

Location	Loc Qty	Loc Code
FP002 9229.	14	
73817	1	
74896	1	
87186	4	
91156	8	

DART AEROSPACE LTD		Work Order:	
Description: Damaged training wearplate from FT. Rucker			
Drawing: D3805		Repair Scheme:	RS1009
Part No: D3805-045		Page:	2 of 1
Batch No:		Qty:	1

Rev	Date	Change Description	Prepared	Checked	Approved
A	11.04.06	New Issue	DD		

U:\Admin\Forms\RepairschemblA.doc

Rev. A

Linda Lacelle

From: David Shepherd <dshepherd@dartaero.com>
Sent: December-07-12 12:24 PM
To: 'Linda Lacelle'; psmith@dartaero.com
Cc: 'David Duval'; 'Eric Downing'
Subject: RE: crack training wear plate

Dave,

Since you are welding the bar closed, should you not be using the ER316L/308L filler rod for stainless rather than the hardcoat rod???

For this one, please add an Engineering Inspection after QC5.

Thanks,
David

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: December-07-12 7:23 AM
To: 'David Shepherd'; psmith@dartaero.com
Cc: 'David Duval'; 'Eric Downing'
Subject: RE: crack training wear plate
Importance: High

QUESTIONS:

Does this have to go to Eagle to be inspected?

Will this have a repair arc, or C of C ?

I want to mark this on the w.o

LL

From: Eric Downing [<mailto:edowning@dartaero.com>]
Sent: December-07-12 9:20 AM
To: 'David Duval'; 'Linda Lacelle'
Cc: 'David Shepherd'; psmith@dartaero.com
Subject: RE: crack training wear plate

I'm ok with that repair/rework work order
Downing

From: David Duval [<mailto:dduval@dartaero.com>]
Sent: Friday, December 07, 2012 8:44 AM
To: Linda Lacelle
Cc: David Shepherd; Eric Downing
Subject: crack training wear plate

Please review RS if there is changes to be done.

Thanks.

David Duval

RA 111454 D3805-045

B92298

Received @ Dart December 5th, 2012
Inspected @ Dart December 6th, 2012

Customer: VECTOR AERO (FT.RUCKER)
Customer Contact: SELENA MacFADDEN
Shipped from: FT.RUCKER AL, USA

Instructions for RA111454 D3805-045 B92298

- Remove D3807-5 gasket (don't discard)
- Strip off all powder coating and 3M adhesive
- Reform wear plate on welding jig
- Re weld cracked wear plate as per QSI 004
- Re powder coat Orange and reapply the D3807-5 gasket as per drawing

Time Estimate = 6 HOUR's

Departments Required: Large Fab (welding), Finishing (powder coating) &
Small Fab (attaching the gasket)

Pictures Attached = NO

QTY INSPECTED = x1

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

Linda Lacelle

From: Eric Downing <edowning@dartaero.com>
Sent: December-07-12 7:08 AM
To: 'David Shepherd'; 'L Lacelle'; 'Melanie Fauteux'; 'Cathy Kerr'; 'Jean Kerr'; 'Nancy MacLeod'
Cc: psmith@dartaero.com; 'Sian Willems'; 'Marc Bellavance'; 'Bill Beckett'
Subject: RE: RA 111454 damaged.wear plate form FT.Rucker

Hey David

I don't know if it will be done on a RS work but yes we will be specifying the rod on the work order and asking for the rods material B#. I don't see why this wouldn't be ready to ship either Tuesday or Wednesday at the latest of next week as long as we get the work order by Monday but Linda should be the person to ask on that.

Downing

From: David Shepherd [<mailto:dshepherd@dartaero.com>]
Sent: Friday, December 07, 2012 12:07 AM
To: 'Eric Downing'; 'L Lacelle'; 'Melanie Fauteux'; 'Cathy Kerr'; Jean Kerr; Nancy MacLeod
Cc: psmith@dartaero.com; 'Sian Willems'; 'Marc Bellavance'; 'Bill Beckett'
Subject: RE: RA 111454 damaged wear plate form FT.Rucker

Eric,

In general, process looks ok to me ... Should we specify the rod to use?
Will you transfer this information to an RS work order like we did last time?
I'd like to see the wearplate after welding and before paint, so if this can be done for Monday, I will still be here to see it. When will the part be ready to ship back to Ft Rucker?

Thanks,
David

From: Eric Downing [<mailto:edowning@dartaero.com>]
Sent: December-06-12 1:21 PM
To: 'L Lacelle'; Melanie Fauteux; Cathy Kerr; Jean Kerr; Nancy MacLeod
Cc: psmith@dartaero.com; Sian Willems; 'Marc Bellavance'; David Shepherd; 'Bill Beckett'
Subject: RA 111454 damaged wear plate form FT.Rucker

Here is the instructions for RA 111454. Please read the attachment that has the work instructions for the rework of the damaged wear plate.

Thanks

Eric Downing
QC Corrdinator